

Work Order ID 63398

October 28, 2010 1:27:31 PM

Page 1

Item ID: D4170-3

Revision ID:

Item Name: Bushing

Start Date: 10/28/10

Start Qty: 24.00

Required Date: 10/29/10

Req'd Qty: 24.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4170

PB1

100

0.00



Hardinge CNC LATHE SMALL

0.00

Hardinge:

Memo

Hardinge CNC Lathe Small

Machine as per Folio FA989

FOLIO REV: 1/1

DWG REV: Pb1

DEBURR

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

~~PRELIMINARY ISSUE~~



Setup Start



Stop



Cust Item ID:

Customer:



16.10.29

10.10.29

24

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Item ID: D4170-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 10/28/10 Start Qty: 24.00



Cust Item ID:

Required Date: 10/29/10 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
125		0.00							
Skidtube	Memo	0.00							
Skidtube	1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								

- inspect to PDI
Dry only
Scrubber (24)
count

N/A 10.11.01

Eng + 8 ship out

SEE WID CHG, OVER
10/20/11 (200) S

POSITIVE
RECALL

POSITIVE RECALL

EFFECTIVE 10/20/11 AUTH 11
RELEASED 10/20/11 DATE 10/20/11

OK FOR RELEASE. ASH 0207
SEE DEN #11-603.

OK to ship 8 QTY 8
TO CHUCK @ ERA FOR
TEST FIT 10.11.01

W/O: 63398		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.10.20	126	CHEM CONV. COAT PER DART QSI 005 4.1	PK	10-11-01	24	CP 10.10.20 QSI 072	S 10/11/01	
10-11-1		QC3. INSPELT PART FINISH.	PK	10/11/01	24		S 10/11/01	

Part No: D4170-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4170-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 10/28/10 Start Qty: 24.00



Cust Item ID:

Required Date: 10/29/10 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/12

MR

10-10-01



Picklist Print

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Work Order ID: 63398



Parent Item: D4170-3



Parent Item Name: Bushing


Start Date: 10/28/10

Required Date: 10/29/10

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 		Purchased	No			100	f	29.2700	0.275	6.947368		10.10.29	
6061-T6 Round Bar .500"													

Location

Loc Qty

Loc Code

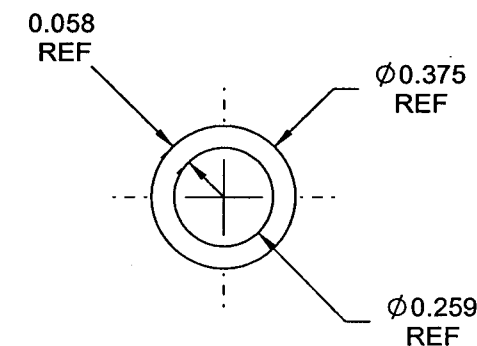
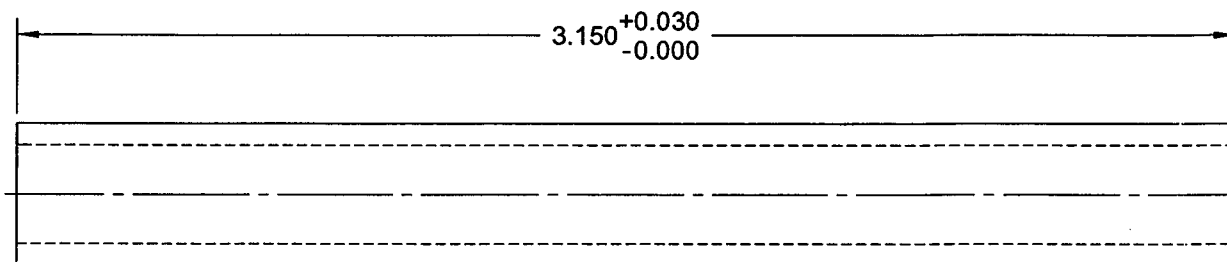
MAT

29.27

114488

29.27

7.385



D4170-1 SPACER

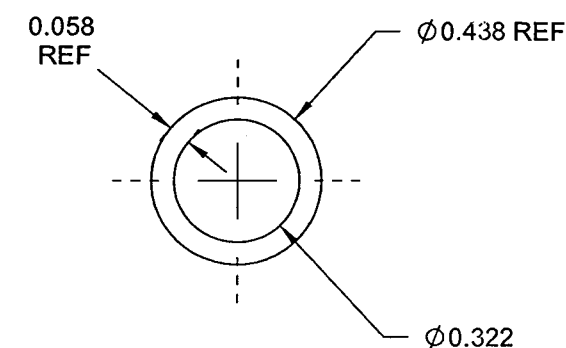
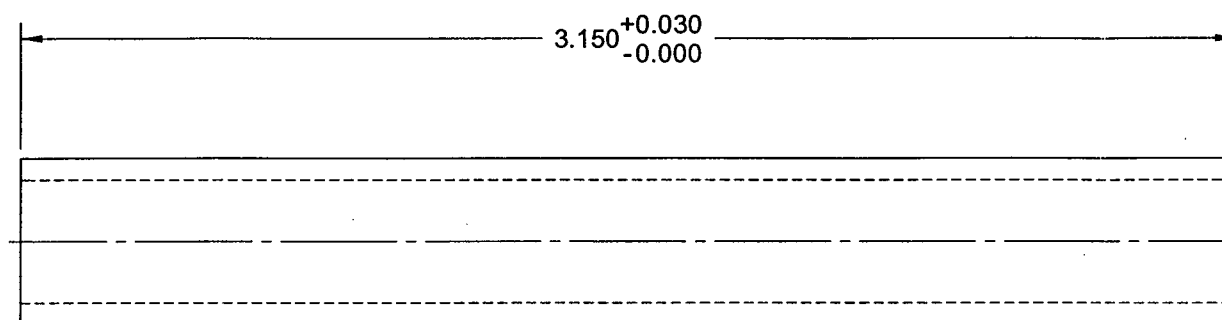
PRELIMINARY ISSUE

Rev. PB1 10.10.28

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, ϕ 3/8 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

7 B \	ADD -3 (SHEET 2)		CP	10.10.25
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	JP			
CHECKED	JP	DRAWING NO.	REV. B	
MFG. APPR.	JP	D4170	SHEET 1 OF 2	
APPROVED	JP	TITLE	SCALE	
DE APPR.		SPACER	NTS	
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D4170-3 SPACER

PRELIMINARY ISSUE

GP 10.10.28

NOTES:

1) MATERIAL: 6061-T6 ROUND BAR, ϕ 7/16 OD
PER QQ-A-225/8, QQ-A-2008, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438

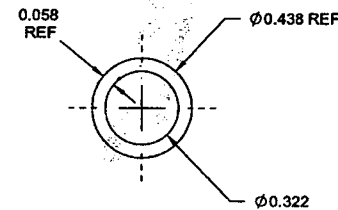
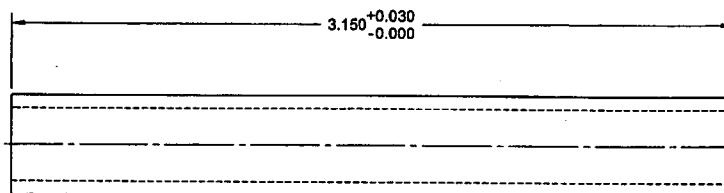
OR

6061-T6 OR 6061-T62 TUBING, ϕ 7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058

- 2) FINISH: *N/A CHEM CONV. COAT PER DART QSI 005 4.1*
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01lbs

GP 10.10.28

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	<i>GP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. <i>B</i>
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NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M8081T6R0.438
- OR
- 6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M8081T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

63398
RELEASE
2010-11-01

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
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